



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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D5374-1

Job Sheet 181909



Part No: D5374-1

Job Qty: 40 ea

Part Name: Bushing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/13/18

Job Tracking No:

Due Date: 9/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 15-12-10 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea		9/28/18	0.00	0.00	Start Up Machining-4	mm	15/10/12 JBS
100	Hardinge	40 pcs		9/28/18	0.00	5.09	Hardinge	11	" "
120	QC	40 pcs		9/28/18	0.00	0.00	QC8	SC 18/10/24	15/10/12 JBS
130	Packaging	40 pcs		9/28/18	0.00	0.00	Packaging3-2	159 OCT 30 2018	2018 25
140	QC21-SA	40 Ea		9/28/18	0.00	0.00	QC21		6

Part Op Descriptions: 100 - 1-TURN AS PER FOLIO FB445 & DWG D5374

DAG
21 OCT 30 2018
9-55

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R0.750	303 Round Bar 0.750	1.3200 ft (.033 ea)	90-Start up Operation	S20132

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M303R0.750	1	112	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.313Inches + 0.000 - 0.003	0.313 0.310	Diameter	
2	Bushing	0.750Inches ± 0.030	0.780 0.720	Diameter	
3	Bushing	0.196Inches + 0.005 - 0.001	0.201 0.195	Diameter	
4	Bushing	0.310Inches ± 0.030	0.340 0.280		
5	Bushing	0.060Inches ± 0.010	0.070 0.050		
6	Bushing	0.020Inches ± 0.010	0.030 0.010		
7	Bushing	30.000Degrees ± 0.500	30.500 29.500	Angle	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																	
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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																																	
Description Work Order Deviation		Disposition																																			
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkebury, ON K6A 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S120132 Part: D5374-1 Job No: 181909 Serial No/Batch: S120132 Revision: Inspector: Exp Date: Instructions: Various STC's Date: 10/22/18		DART AEROSPACE		Completed By																																	
				Lead hand / Supervisor Approval Verification																																	
				QC / QA Coordinator Approval																																	
Root Cause <table style="width:100%;"> <tr><td>Environment ☐</td><td>No Re-verification ☐</td></tr> <tr><td>Design ☐</td><td>Operator ☐</td></tr> <tr><td>Doc/Data ☐</td><td>Offset/Setup ☐</td></tr> <tr><td>Equip/Tooling ☐</td><td>Supplier ☐</td></tr> <tr><td>Handling/Pre ☐</td><td>Training ☐</td></tr> <tr><td>Material ☐</td><td>Use for Testing ☐</td></tr> <tr><td>Internal Transport ☐</td><td>Poor Information ☐</td></tr> <tr><td>Tribal Knowledge ☐</td><td>Rushing ☐</td></tr> <tr><td>LOA ☐</td><td>Product Improvement ☐</td></tr> <tr><td>Substation ☐</td><td>Process Improvement ☐</td></tr> <tr><td>Past Expiry Date ☐</td><td>Manufacturing Process ☐</td></tr> <tr><td>Misidentified ☐</td><td>Past Due ☐</td></tr> </table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	<table style="width:100%;"> <tr> <td>Heat Treat ☐</td> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> </tr> <tr> <td>Wave/Twist in Tube ☐</td> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> </tr> <tr> <td>Marks/Chatter ☐</td> <td>Drill Holes ☐</td> <td>Misaligned/off center ☐</td> </tr> </table>		Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence
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